

Work Order ID 89333

89333

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August-24-12 1:12:51 PM

Item ID: D3838-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop *NS2*

Start Date: 8/21/12 Start Qty: 1.00

Required Date: 9/14/12 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/08/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3838	Rev A

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAD

12-11-08

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M122130

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: M122130

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

CC

12-11-19

(3x)

Work Order ID 89333

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Item ID: D3838-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly (Basket Lid, LH)
Start Date: 8/21/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/14/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130						③	12-11-21		DA 09 2-89
QC	Memo	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140						③	12-11-21		DA 09 2-89
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location <i>W/A</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

160

QC21 - FINAL Inspection - w/o Release

CC 12-11-21 ③
12/11/22
ME
12-11-21

Picklist Print

August-24-12 1:12:50 PM

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Work Order ID: 89333

Parent Item: D3838-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 8/21/12

Required Date: 9/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 Bushing		Manufactured	No				Each	200.0000		1		CC 12-11-19	
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Location

Loc Qty

Loc Code

WA	199	
79213	1	
83464	18	
86550	180	
WA005	1	
66489	1	

B89780 → (3x)

M304TS0.750W.065

304 SQ Tube .75x.75x.065W

Purchased

No

100

f

1,755.1103

1.0317

~~1.0317~~

3.25P

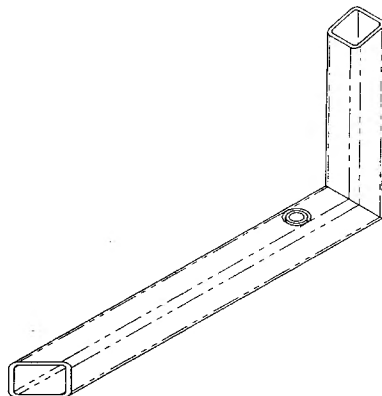
SAD 12-11-08

Location

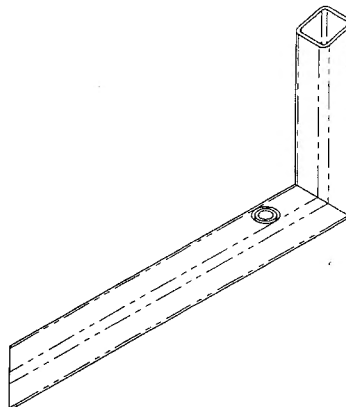
Loc Qty

Loc Code

MAT	714.1103	
112398	0	
122051	714.1103	
MAT017	1000	
122468	1000	
MAT018	41	
7636	41	



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

CHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 89333 MLJ

12/08/28

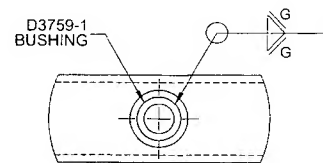
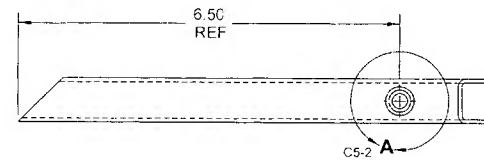
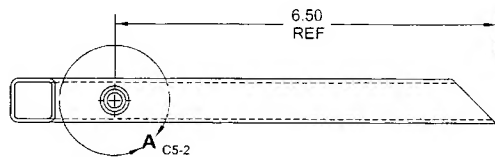
RELEASED
08/11/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.54 lbs

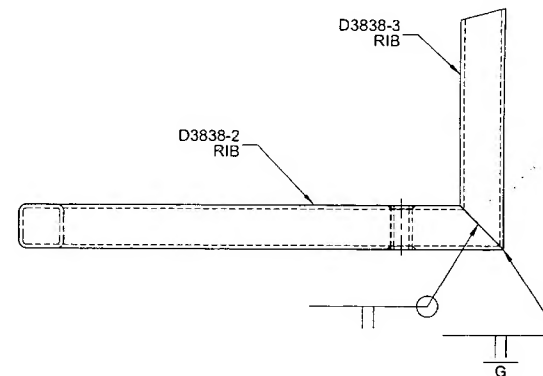
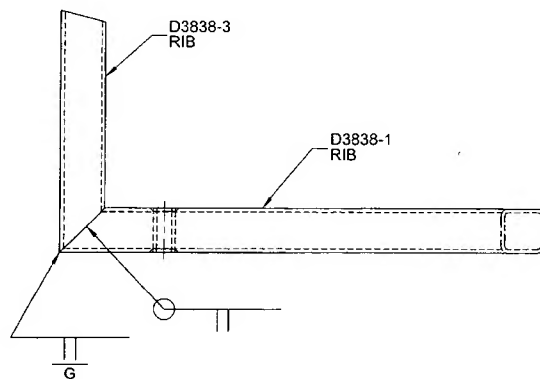
A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3838	REV. A
TITLE RIB ASSY (BASKET LID)	SCALE NTS
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DETAIL A
D2-2 SCALE 2X
D7-2

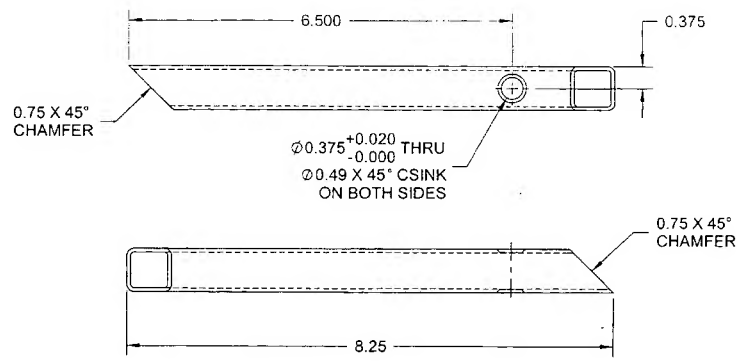


D3838-041 RIB ASSY (BASKET LID, LH)

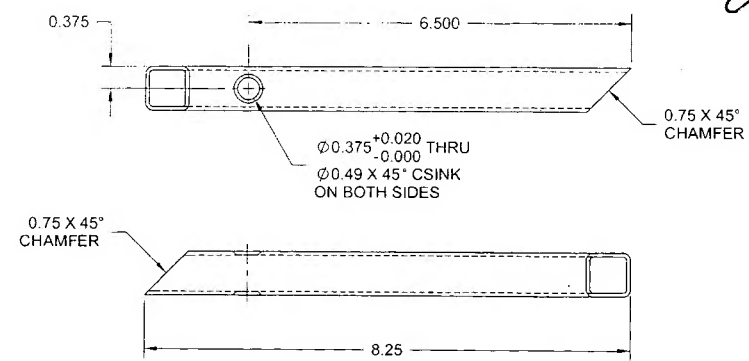
D3838-042 RIB ASSY (BASKET LID, LH)

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08/11/18/14

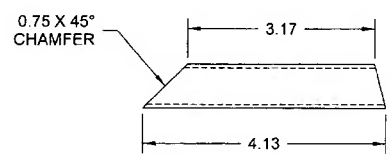
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MFG. APPR.		TITLE	SHEET 2 OF 3
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DE APPR.			NTS
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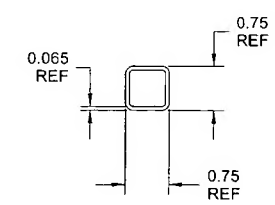
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

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